

# Work Order ID 80243

**\*80243\***

Page 1

February-15-12 3:30:31 PM

Item ID: D3436-044 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Step RH  
 Start Date: 15/02/2012 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 29/02/2012 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: M.C.S Date: 12/02/16 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3436	Rev A

100 0.00  
**\*100\*** Large Fab  
 Large Fab  
 Large Fab

**Memo** 0.00  
 Weld bushings D3436-5 and clamp D3436-1 using welding Jig DT8772 and Dwg D3436Dwg Rev: A  
 Qty Part Number Description Batch  
 A/RN/A 4130 Welding Rod M118875  
 Weld right step D3436-4 using welding Jig DT8773 and Dwg D3436Dwg Rev: A  
 Qty Part Number Description Batch  
 A/RN/A 4130 Welding Rod M118875  
 Weld cap D3436-7 as per Dwg D3436Dwg Rev: A  
 Qty Part Number Description Batch  
 A/RN/A 4130 Welding Rod M118875

(4) A 12-11-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

February-15-12 3:30:31 PM

**\*80243\***

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**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**\*4\***

**Cust Item ID:**

**\*4\***

**Customer:**

Run Start \*NR1\*

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Insp.  
Stamp**

0.00

**\*110\***

## BAND SAW

0.00

## Bandsaw

## Memo

## Jeaspa Bandsaw

1-Slit part D3436-041 on bandsaw as per Dwg D3436  
2- deburr

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

**\*120\***

## Memo

0.00

QC

## Quality Control

130

QC5- Inspect part completeness to step on W/O

0.00

**\*130\***

## Memo

0.00

QC

## Quality Control

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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 Item Name: Step RH  
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 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
<b>*140*</b> Powdercoat Powder Coating	Memo START TIME: <u>8:00</u> OVEN TEMPERATURE: <u>400 OF</u> FINISH TIME: <u>8:30</u>	0.00				4X			<u>12/11/15</u> <u>MJ</u>
145	Wing Walk as per dwg QSI005 4.4 Batch	0.00							
<b>*145*</b> HandFinish Hand Finishing	Memo Wing Walk B <u>M123652</u>	0.00				4X			<u>12/11/15</u> <u>MJ</u>
150	QC3- Inspect Part Finish	0.00							
<b>*150*</b> QC Quality Control	Memo	0.00				4			<u>12/11/15</u> <u>MJ</u>

M122878

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**\*80243\***

Page 4

**\*N900040100\***

Setup Start \*NS1\*

Stop **\*NS2\***

**Start Date:** 15/02/2012    **Start Qty:** 4.00    **\*4\***

**Cust Item ID:**

**Required Date:** 29/02/2012      **Req'd Qty:** 4.00      **\*1\***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

**Insp.  
Stamp**

0.00

**\*155\***

0.00

### Small Fab

## Memo

Bond pads per dwg and QSI 015

M123 557

0.00

**\*160\***

0.00

QC

## Memo

## Quality Control

QC5- Inspect part completeness to step on W/O

0.00

170

**\*170\***

0.00

### Packaging

## Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 80243**

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Item ID: D3436-044

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Step RH

Stop **\*NS2\***

Start Date: 15/02/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 29/02/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

Memo

0.00

Quality Control

12/11/20 JJ

mf  
12-11-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

February-15-12 3:30:34 PM

Page 1

Work Order ID: 80243

\*80243\*

Parent Item: D3436-044

\*D3436-044\*

Parent Item Name: Step RH

Start Date: 15/02/2012

Required Date: 29/02/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A 05.05.11New IssueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3436-5		Manufactured	No			100	Each	24.0000	4	16			

\*D3436-5\*

Bushing

\*\*

EL 12-11-13

Location	Loc Qty	Loc Code
ST044	20	
46592	20	
WA024	4	
75229	4	

D3436-7

Manufactured No

100 Each 35.0000 1 4

\*D3436-7\*

Cap

\*\*

EL 12-11-13

Location	Loc Qty	Loc Code
WA021	35	
56836	35	

D3436-9

Manufactured No

100 Each 4.0000 2 8

\*D3436-9\*

Pad

\*\*

8 FF 12-11-16

Location	Loc Qty	Loc Code
GA 87279	4	
79670	4	

D3436-4

Manufactured No

100 Each 3.0000 1 4

\*D3436-4\*

Right Step

\*\*

EL 12-11-13

Location	Loc Qty	Loc Code
WA022	3	
73545	3	

80251 x 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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February-15-12 3:30:34 PM

Page 2

Work Order ID: 80243

\*80243\*

Parent Item: D3436-044

\*D3436-044\*

Parent Item Name: Step RH

Start Date: 15/02/2012

Required Date: 29/02/2012

Start Qty: 4.00

Required Qty: 4.00

D3436-1

Manufactured No

155

Each

33.0000

1

4

\*D3436-1\*

\*\*

EL 12/1/13

Clamp

Location

Loc Qty

Loc Code

WA024

33

17679

33

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

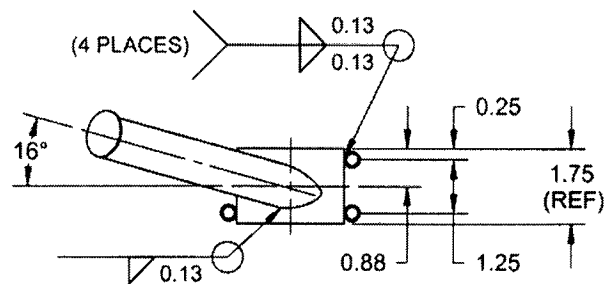
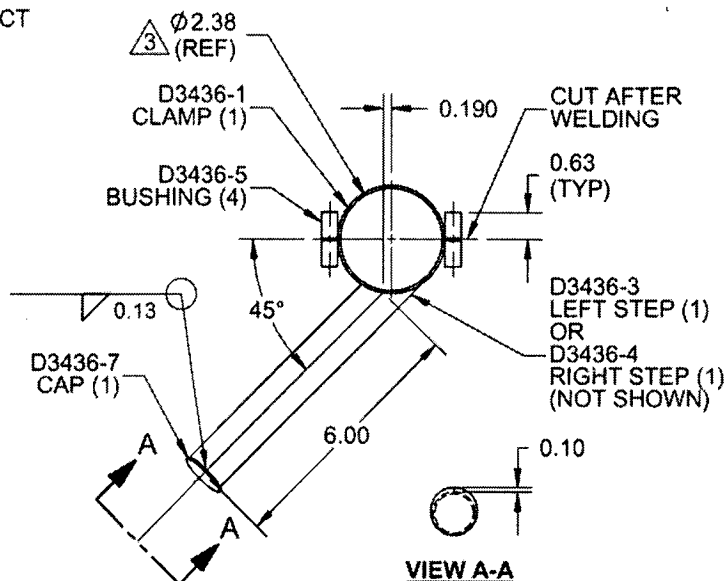
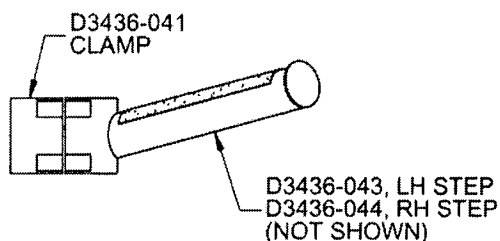
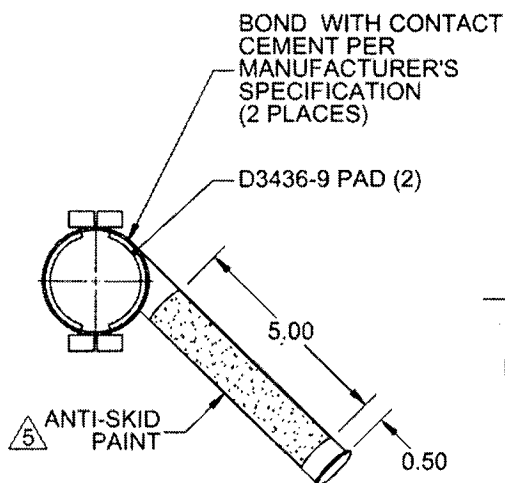
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3436</b>	REV. A SHEET 1 OF 4
DATE <b>05.04.28</b>	TITLE <b>MAINTENANCE STEP</b>		SCALE 1:4
A	05.04.28	NEW ISSUE	



**WELDING**

**NOTES:**

- 1) POSITION PARTS AS PER JIGS DT8772 AND DT8773
- 2) WELD PER DART QSI 004
- 3) FILLET BOTH TOP AND BOTTOM EDGES OF CLAMP ALONG 2.38 I.D. SECTION TO 0.03 RADIUS TO PREVENT SCORING AND SCRATCHING OF SKID CROSS TUBE
- 4) FINISH: POWDER COAT WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
- 5) APPLY BLACK ANTI-SKID PAINT AS SHOWN PER DART QSI 005 4.4
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

**RELEASED**

05-05-27 *[Signature]*

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SUBJECT TO  
VENDOR  
WORK

NO. **80243**  
*ALJ*  
**12/02/16**

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

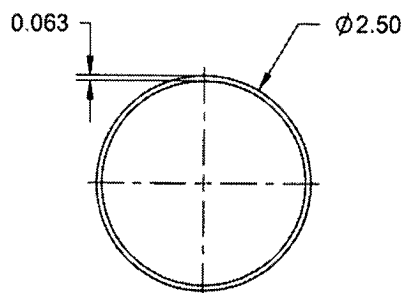
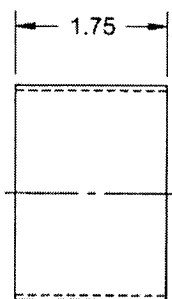
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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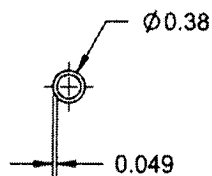
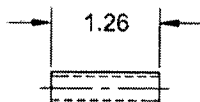


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3436</b>	REV. A SHEET 2 OF 4
DATE <b>05.04.28</b>	TITLE <b>MAINTENANCE STEP</b>		SCALE 1:2



#### **D3436-1 CLAMP**

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T2500W063)



#### **D3436-5 BUSHING**

- 2) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T0375W049)

#### **D3436-1/-5, GENERAL NOTES:**

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) ALL DIMENSIONS ARE IN INCHES  
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

RELEASED

05-05-27 *[Signature]*

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80243

**Dart Aerospace Ltd**

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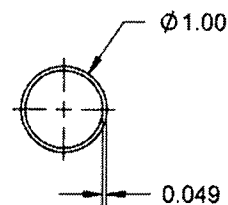
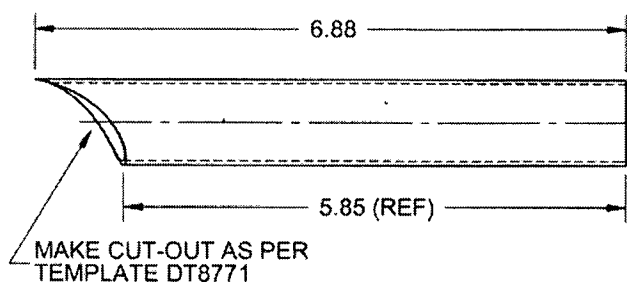
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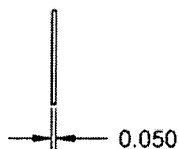
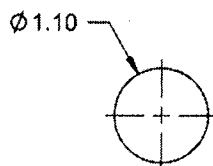
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3436</b>	REV. A SHEET 3 OF 4
DATE <b>05.04.28</b>		TITLE <b>MAINTENANCE STEP</b>	SCALE 1:2



#### **D3436-3 LEFT STEP**

(D3436-4 RIGHT STEP - OPPOSITE, NOT SHOWN)

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T1000W049)



#### **D3436-7 CAP**

- 2) MATERIAL: AISI 4130N STEEL SHEET PER MIL-S-18729, AMS6350 OR AMS 6351 (REF. DART SPEC. M4130N-S050)

RELEASED

05-05-27 *[Signature]*

#### **D3436-3/-7, GENERAL NOTES:**

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) ALL DIMENSIONS ARE IN INCHES  
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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60243

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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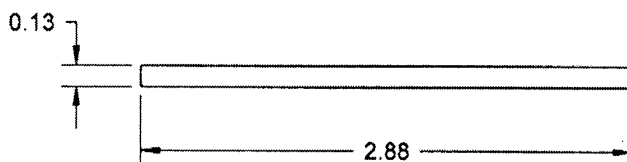
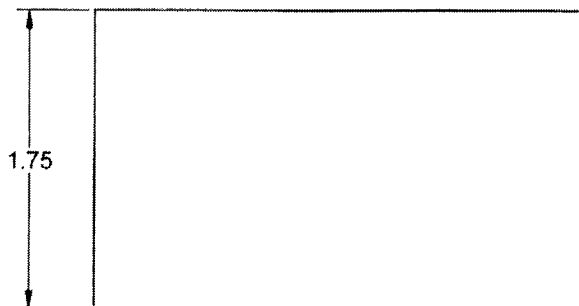
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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**NOTE:** Date & initial all entries



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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. <b>D3436</b>	REV. A SHEET 4 OF 4
DATE <b>05.04.28</b>	TITLE <b>MAINTENANCE STEP</b>		SCALE 1:1



RELEASED  
05-05-27 [Signature]

**D3436-9 PAD**

**NOTES:**

- 1) MATERIAL: 60 DUROMETER NEOPRENE SHEET, 1/8" THICK  
(REF. DART SPEC. M-NEO60-S.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries